

October 22, 2009 11:26:08 AM



**Accept**

**Setup Start**

**Stop**



**Item Name:** Hinge Assembly, Lower Door

**Start Date:** 21/10/2009      **Start Qty:** 5.00

**Cust Item ID:**

**Required Date: 30/10/2009      Req'd Qty: 5.00**



**Customer:**

**Reference:**

Run Start



**Approvals:**

### Process Plan:

Date: 07/0-27

### Tooling:

**Date:**

**Stop**



**QC:**

Date:

**SPC (Y/N):**

**Date:**[illegible]

**Work Order ID 53044**

Page 2

October 22, 2009 11:26:08 AM

Item ID: D3813-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Assembly, Lower Door

Start Date: 21/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/12/17   
MF  
09-12-16

# Picklist Print

October 22, 2009 11:26:25 AM

Page 1

Work Order ID: 53044

Parent Item: D3813-043RevA

Parent Item Name: Hinge Assembly, Lower Door

Comments:

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3518-3RevB		Manufactured	No			100	Each	18.0000	5.0000			
Stainless Steel Ball Joint Rod End												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	3	
48211	3	
Main Warehouse		
ST109	15	
51108	5	
52270	10	

D3813-3RevA		Manufactured	No			100	Each	7.0000	5.0000			
Hinge, Lower Door												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	7	
42053	1	
45796	8	

MS124738		Purchased	No			100	Each	8.0000	5.0000			
Heli-Coil 3/8-24 unf												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	8	
109249	8	

M113288

SX m.l 09/12/16

SX m.l 09/12/16

SX m.l 09/12/16

# Picklist Print

October 22, 2009 11:26:25 AM

Work Order ID: 53044

Parent Item: D3813-043RevA

Parent Item Name: Hinge Assembly, Lower Door

Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-6		Purchased	No			100	Each	18.0000	5.0000			

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

109249

8

112492

10

M 113147

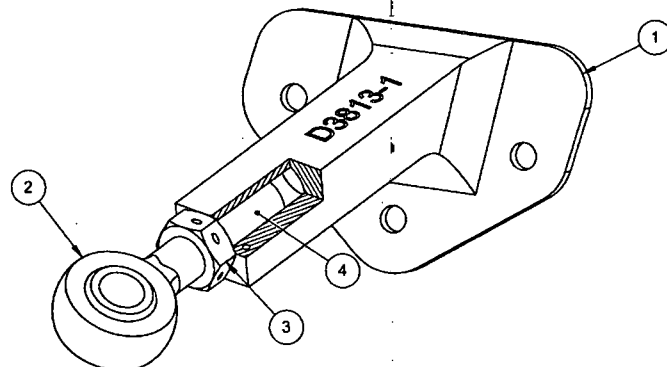
SX

m-1/2 09/12/16

SHOP COPY

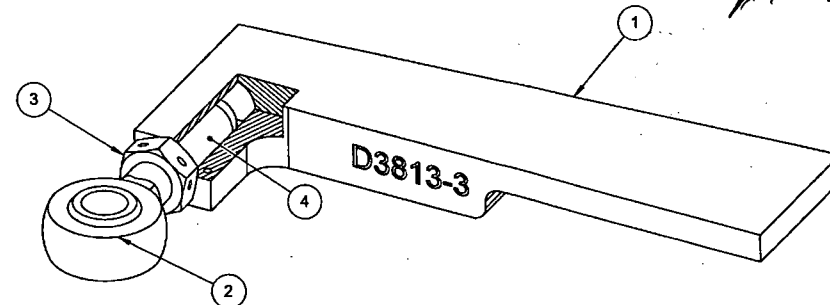
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENTS  
WITHOUT NOTICE  
WORK ORDER  
NO. 53044

*109-10-22*



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

**D3813-041 HINGE ASSY, UPPER DOOR**



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

**D3813-043 HINGE ASSY, LOWER DOOR**

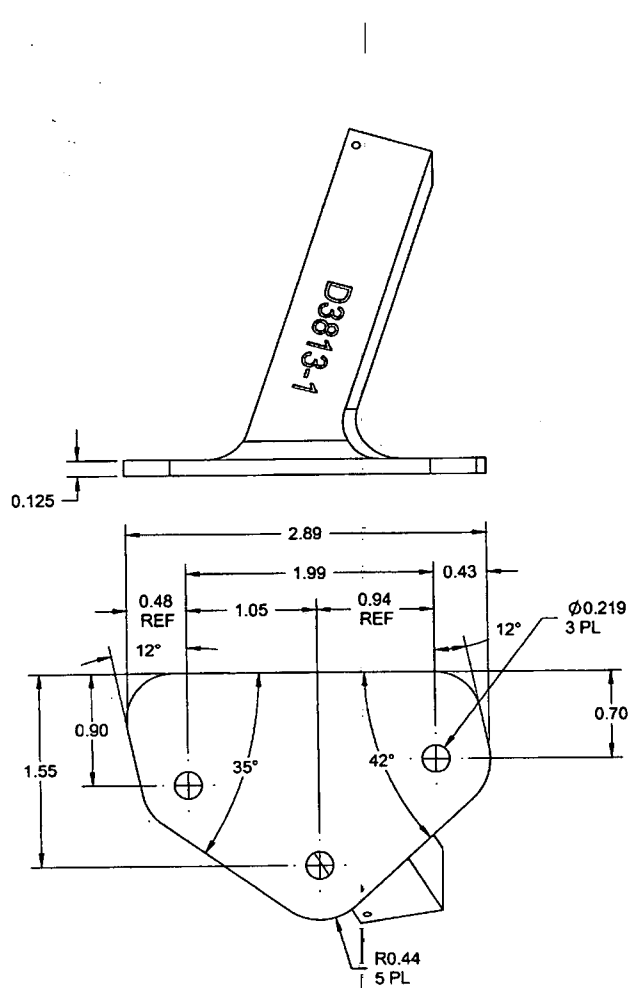
**RELEASED**  
*09/01/13*

A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3813</b>	REV. A SHEET 1 OF 4
TITLE <b>HINGE</b>	SCALE NTS

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53044



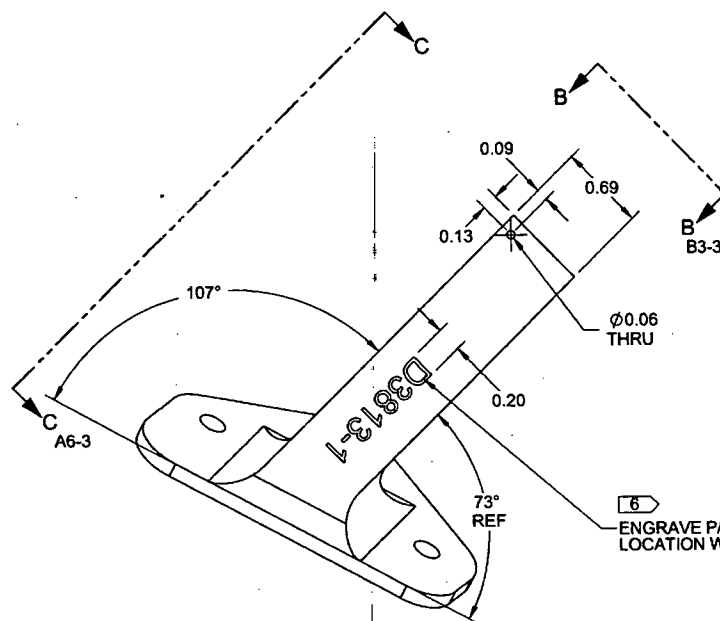
D3813-1 HINGE, UPPER DOOR

## NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.14 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3813	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
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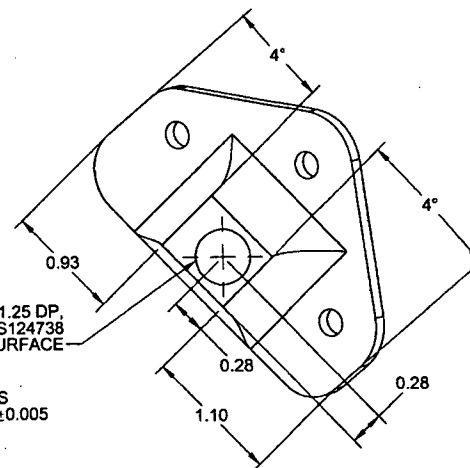
530441



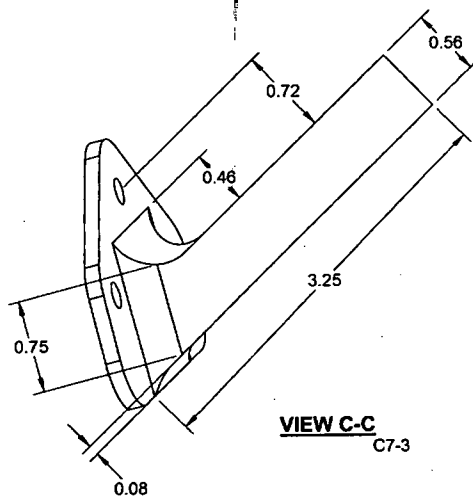
**VIEW A-A**  
C4-2

Ø0.391 X 1.25 DP,  
INSTALL HELICOIL MS124738  
FLUSH WITH SURFACE

ENGRAVE P/N TO DEPTH OF 0.005 IN THIS  
LOCATION WITH TOOL TIP RAD OF 0.015±0.005



**VIEW B-B**  
D5-3



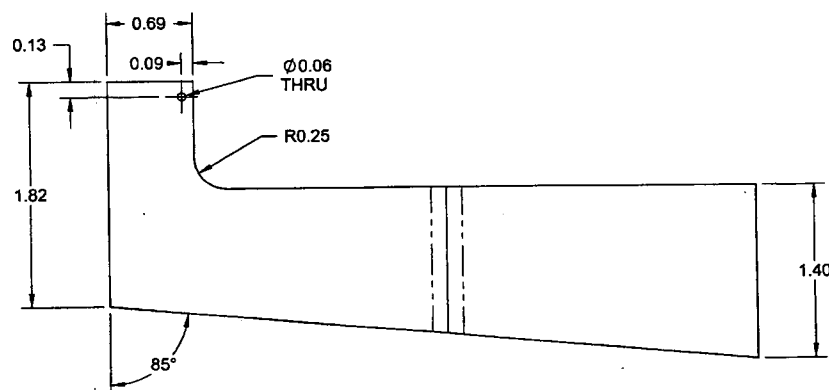
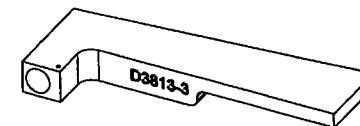
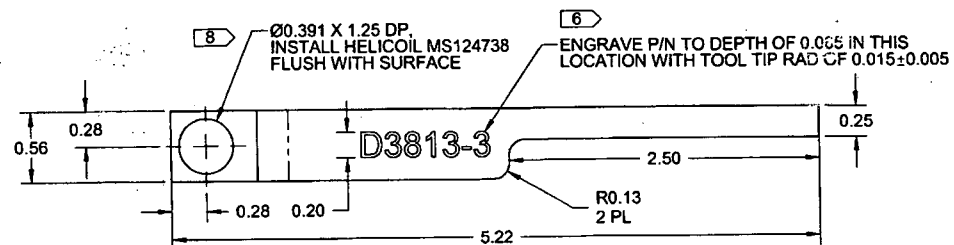
**VIEW C-C**  
C7-3

**D3813-1 HINGE, UPPER DOOR**

**RELEASED**  
09/01/13

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53044



**D3813-3 HINGE, LOWER DOOR**

**RELEASED**  
09/07/13 MD

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.24 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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